

Work Order ID 68775

Thursday, April 21, 2011 8:47:42 AM



Page 1

Item ID: D3578-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 4/20/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: NDate: 11-04-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3578	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3578 (Run prog. D3578-1)

Dwg Rev: AProg Rev: A

2-Deburr if necessary

B11-5-4(100)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-5-4

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

81105104counts(100)asp019

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

EB 4/25/05 *(100)*

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

D 4/25/05

Went
(100)

150

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

100 *pl* 4/25/05

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Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

= m/l 11/05/05 (100x)

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble as per dwg D3578

E 4/05/12 @

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/05/12

counts (100)

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Identify as per dwg & Stock Location: 24SA

0.00



Packaging

Memo

0.00

Packaging

11/5/13 (100)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/16 (100)11-05-16
(100)

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 8:47:48 AM

Page 1

Work Order ID: 68775

Parent Item: D3578-041

Parent Item Name: Doubler



Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A 07.04.11 New issue EC
IPP RevB 10.10.21 remove D3569-1 DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20426AD3-3 Rivet		Purchased	No			110	Each	2,867.000	2	80			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST316				2867					
					19099			2867					
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			170	sf	425.5000	0.007	0.294737			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT021				425.5					
				116268				34.5					
				116700				65					
				117285				326					
MS21075L3 Nutplate		Purchased	No			170	Each	58.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST303				58					
					116706			58					

4/24/05/12

200

B 11-5-4

(100)

116700

4/24/05/12

59

M 117677 (41X)

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Dart Aerospace Ltd

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SHOP COPY

RE

ENG

DART

UNCONTROLLED COPY

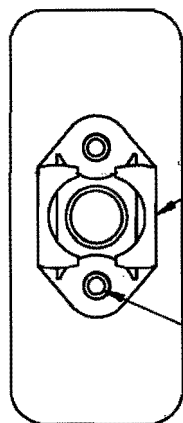
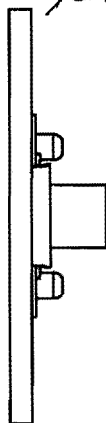
SUBJECT TO AMENDMENT

WITHOUT NOTICE

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>JB</i>	DRAWING NO. D3578	REV. A SHEET 1 OF 1
DATE 07.01.12	TITLE DOUBLER SCALE 3:2		
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	

WORK ORDER

NO. **48725**



D3578-1 PLATE

MS21075L3 NUT PLATE

MS20426AD3-3 RIVET
(2 PLACES)

RELEASED
07.04.02

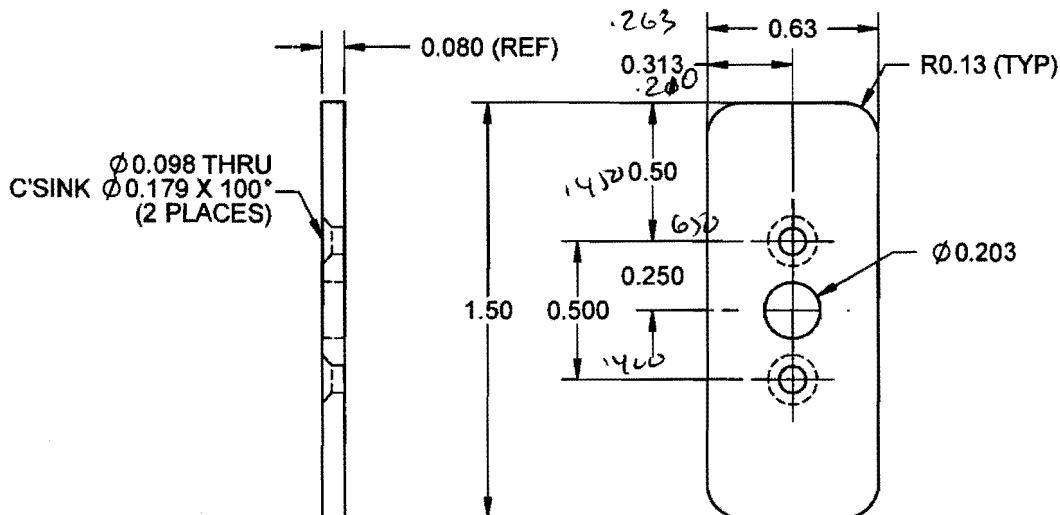
D3578-041 PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

D3578-041 DOUBLER

D3578-041 NOTES:

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER



D3578-1 PLATE

D3578-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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